

Work Order ID **76280*****76280***

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Tuesday, November 08, 2011 1:30:49 PM

Item ID: D3748-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Hinge Half

Start Date: 11/8/2011 Start Qty: 6.00

6

Cust Item ID:

Required Date: 11/22/2011 Req'd Qty: 6.00

6

Customer:

Reference:

Run Start ***NR1***Approvals: Process Plan: MLJ Date: 11/11/08 Tooling: _____ Date: _____Stop ***NR2***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3748

Rev A

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3748 Dwg Rev: A Prog Rev: A 2-
Deburr if necessary

361.125

B11-12-5

110

0.00

110

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

B11-12-5

120

0.00

120

QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

Suliz/05(412)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 76280

76280

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Tuesday, November 08, 2011 1:30:49 PM

Item ID: D3748-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Hinge Half
 Start Date: 11/8/2011 Start Qty: 6.00 ***6*** Cust Item ID:
 Required Date: 11/22/2011 Req'd Qty: 6.00 ***6*** Customer:

Reference: Run Start ***NR1***
 Stop ***NR2***
 Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Small Fab	Small Fab	0.00							
Small Fab	Memo	0.00							
Small Fab	1- Deburr if necessary								
140 *140* QC	QC5- Inspect part completeness to step on W/O	0.00							
Quality Control	Memo	0.00							
150 *150* Brake NC	NC BRAKE	0.00							
Brake NC	Memo	0.00							
Brake NC	Bend as per Dwg D3748 using DT9510								

SB 11/12/11

12

W/O:		WORK ORDER CHANGES					
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Revision ID: Stop ***NS2***
Item Name: Hinge Half
Start Date: 11/8/2011 Start Qty: 6.00 ***6*** Cust Item ID:
Required Date: 11/22/2011 Req'd Qty: 6.00 ***6*** Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				<u>8/2</u>			
170 *170* Packaging Packaging	Identify as per dwg & Stock Location: <u>W/A</u> Memo *****STOCK IN BASKET CELL*****	0.00 0.00				<u>8/2</u>	<u>0</u>		
180 *180* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							<u>11/12/2011</u>

11/12/2011
12

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Tuesday, November 08, 2011 1:30:53 PM

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Work Order ID: 76280

76280

Parent Item: D3748-1

D3748-1

Parent Item Name: Hinge Half

Start Date: 11/8/2011

Required Date: 11/22/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A 08-01-30 new issue DD verified by:EC
IPP Rev:B 08-02-27 rev.A as per ecn 1139 DD verified by:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304S11GA

Purchased

No

100

sf

101.8000

0.0341

0.215368

**

RB 11-12-5

M304S11GA

304/316 0.125 Sheet

Location

Loc Qty

Loc Code

MAT020

101.8

119006

48.5

119048

53.3

119040

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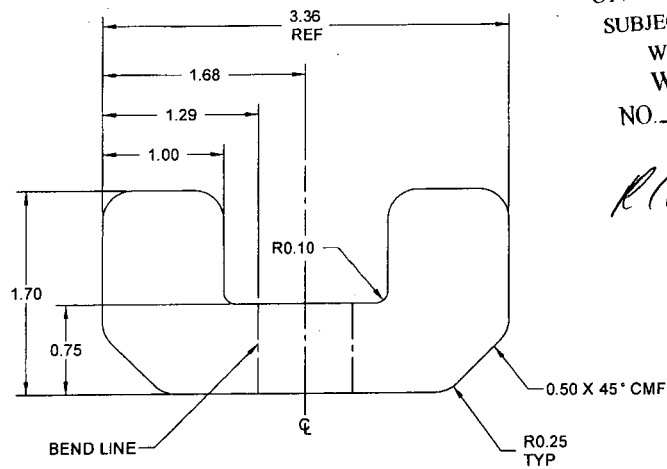
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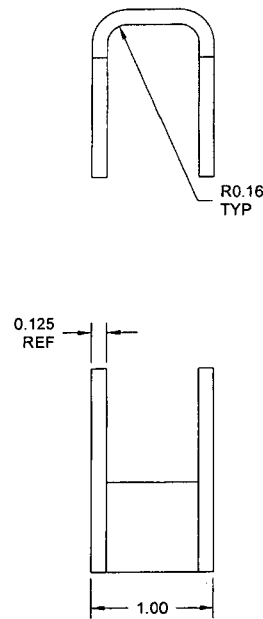
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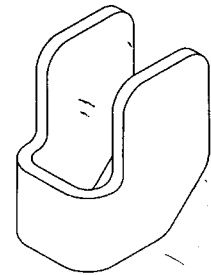


D3748-1F FLAT PATTERN

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER NO. 76280
R11-11-08



D3748-1 HINGE HALF



NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.125 THICK
PER MIL-S-5019 (ANNEALED) 2B FINISH
(REF. DART SPEC M304S11GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.15 lbs

A		INITIAL RELEASE		AJS	08.02.05
REV.		DESCRIPTION		BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			
DRAWN	AJS				
CHECKED	JE	DRAWING NO. D3748			REV. A
MFG. APPR.	MD				SHEET 1 OF 1
APPROVED	MD	TITLE HINGE HALF			SCALE
DE APPR.	MD				1:1
DATE	08.02.05	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR DISSEMINATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

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